



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW109-3130-54-111
Job Sheet 196741



Part No: RBW109-3130-54-111

Job Qty: 1 pcs *5*

Part Name: Tail Rotor Ring Nut Removal Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 8/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17220

Note: DWG RBW109-3130-54-111 Rev 0 IPP Rev. A 19.05.01 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S207503



Part: RBW109-3130-54-111

Job No: 196741

Serial No/Batch: S207503

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/21/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	8/20/19		0.00	0.05	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	8/20/19		0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	8/20/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	1 pcs	8/20/19		0.00	0.00	QC 21 - FG - 21		DAS 21 9-89
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - 1-Assemble 2-Pick bag and tag. 3-Ensure pieces do not hit/rub up against each other in the bag. Package Descriptions: accordingly.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN174-5	A/C Bolt	10 Ea (2 ea)	100-Small Fab - 1	3196258
RBW109-3130-54-111-1	Wrench	5 pcs (1 ea)	100-Small Fab - 1	3202247
RBW109-3130-54-111-3	Stop	1 pcs (1 ea)	100-Small Fab - 1	3202167

Job Allocations

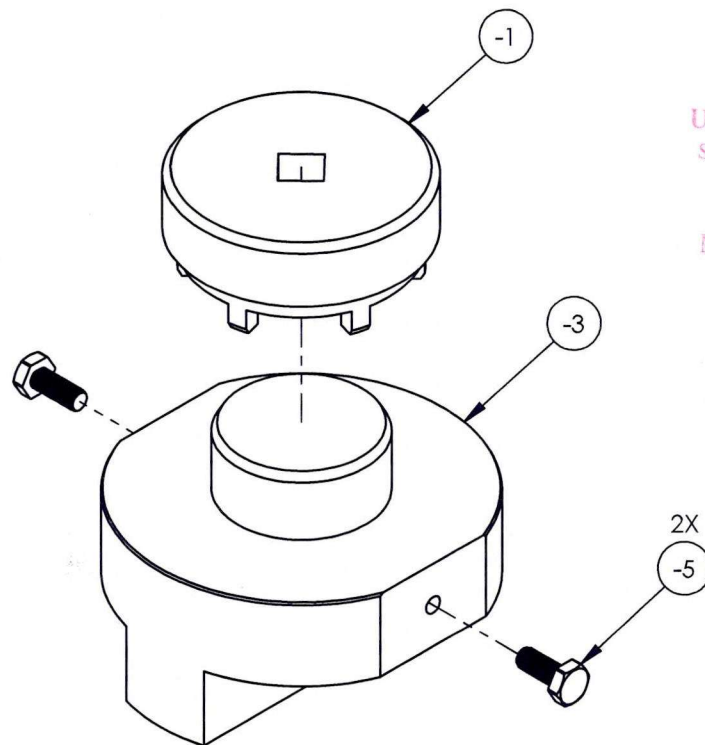
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	AN174-5	2	0	0
	RBW109-3130-54-111-1	1	0	0
	RBW109-3130-54-111-3	1	0	0

Part Specifications	
Specifications could not be found.	

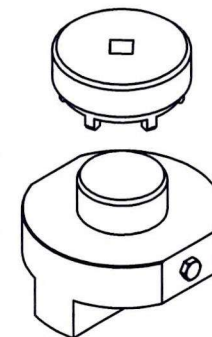
Plex 6/20/19 11:43 AM Dart.lajeunesse.marie

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 190741 MW
190621



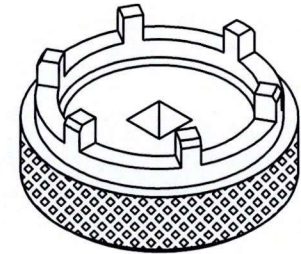
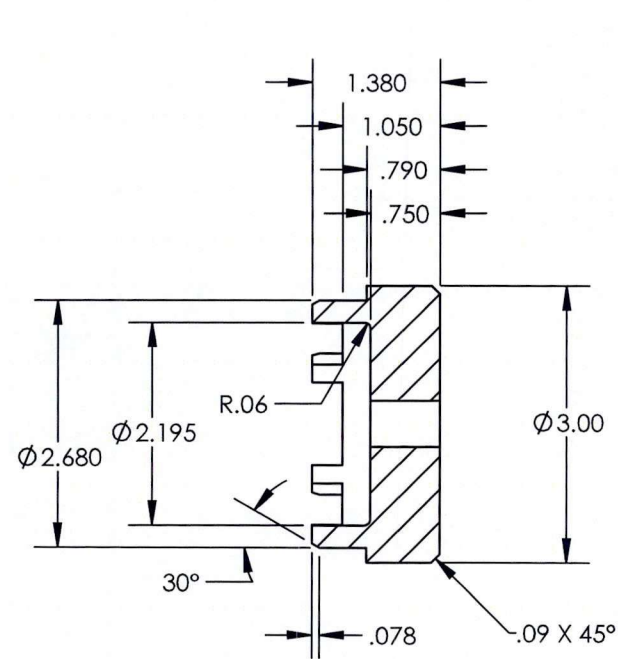
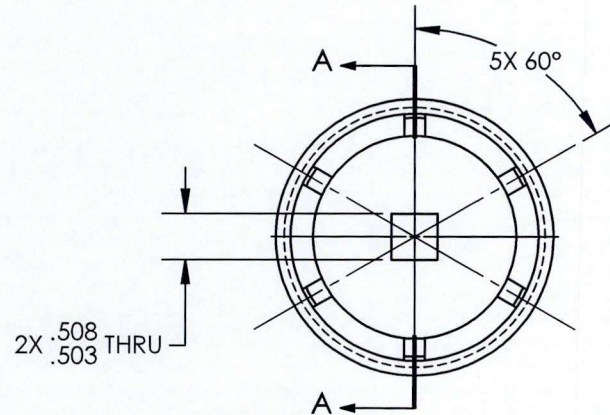
NOTE:
REF. AGUSTA T/N: 109-3130-54-111.

RED BARN MACHINE	
TITLE T/R RING NUT REMOVAL, TOOL ASSY.	
DWG NO. RBW109-3130-54-111	REV
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: MARPET APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW109
SCALE 1:2	DATE 5/31/2013
SHEET 1 OF 3	

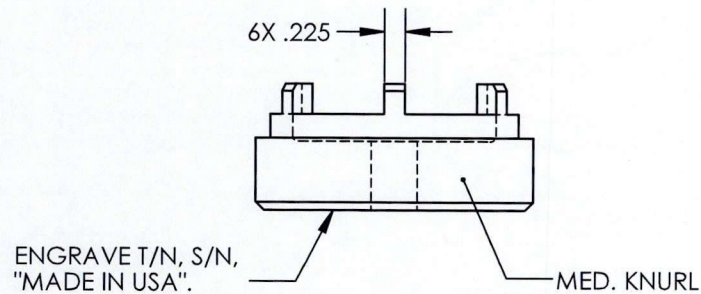
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	WRENCH	4140 Q&T	Ø3-1/8 X 1-1/2	2
			-3	1	STOP	6061	Ø4-1/2 X 3-1/8	3
			-5	2	A/C BOLT	STEEL	1/4-28 X 5/8 AIRCRAFT SPRUCE #AN174-5	1

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SECTION A-A



(-1)
WRENCH

RED BARN MACHINE	
T/R RING NUT REMOVAL, TOOL ASSY.	
DWG NO. RBW109-3130-54-111-1	REV
MAT'L 4140 Q&T	DRAWN BY: MARPET
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D West</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW109
SCALE 1:2	DATE 5/31/2013
SHEET 2 OF 3	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					